

Date: Tuesday, 28/10/2008 3:40:22 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI ACCESS STEP LH
Job Number : 43029	
Estimate Number : 10855	
P.O. Number :	Part Number : D206628021
This Issue : 28/10/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : N/A
Previous Run : 42583	Material :
Written By :	Due Date : 16/11/2008 Qty: 4 Um: Each
Checked & Approved By : <u>JLD 08-10-29</u>	
Comment : Est Rev:D as per ECN 766 JLM Est Rev:E as per ecn 1118 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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for JLD 08/11/10

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-021 CHG 0023 JLD. Sorbeler

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	43029A	206L /407 STEP ASSY, LH
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**Comment:** Sub-Component Step Assembly1 x D2724-041 Batch 43029A

4.0	D2732030	Rubber Cushion
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**Comment:** Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rubber Cushion

batch 38509

*this batch is still not in comp **

5.0	AN414A	Bolt
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

batch M107534

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

D27317

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 D2731-7 Mounting Lug

~~41317~~ 41597

SS 09/01/08 (x4)

7.0

D3394043

Lug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
4 D3394-043 LUG ASS,Y

B4388 x 1/2 B34834 x 1/2

SS 09/01/09

SS 09/01/08 (x4)

8.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number Description Batch
8 AN4-15A Bolt

M108868 x

SS 09/01/08 (x4)

9.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch
12 AN960JD416 Washer

M109249

SS 09/01/08 (x4)

10.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch
12 MS21042L4 Nut (or MS21042-4)

M108145

SS 09/01/08 (x4)

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 09/01/08 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



4x

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-021

Location: 7L

PPP Rev: F

9/1/9

SD

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-01-59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

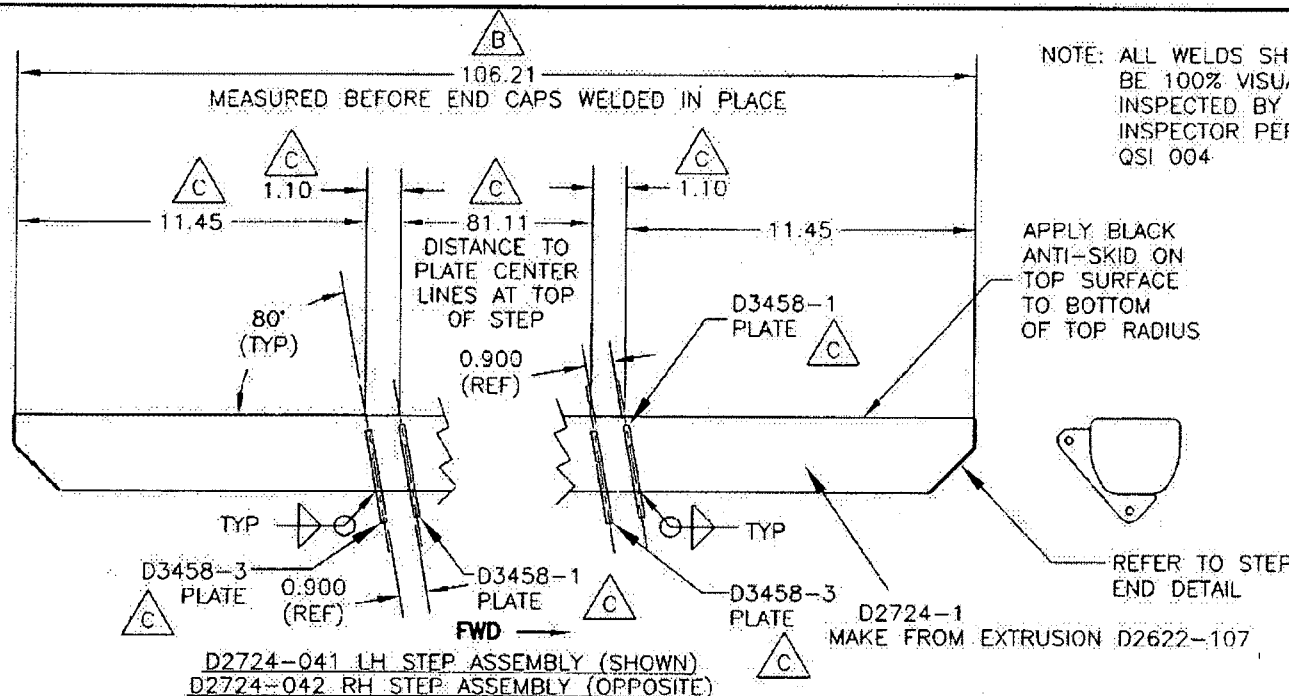
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

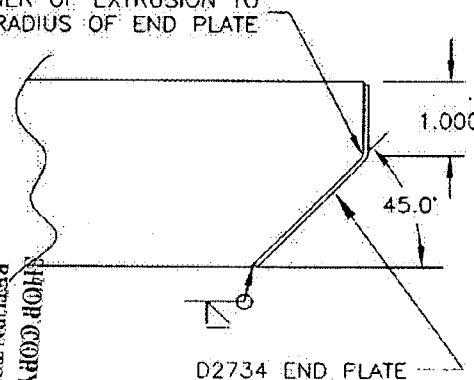
DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO ORDER
WFO
NO 13024

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, MA
CHECKED	APPROVED	DRAWING NO.
05.09.19	05.09.19	D2724
DATE	TITLE	206L/407 STEP ASSEMBLY
A	97.12.04	NEW ISSUE
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
C	05.09.19	RE-DESIGN, ADD D3458-1/-3
SCALE	NTS	

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